

Work Order ID 67590

Monday, March 28, 2011 11:42:48 AM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 3/28/2011 Start Qty: 16.00

Required Date: 3/31/2011 Req'd Qty: 16.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

QC:

Date: 4/03/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* Dwg Rev. D Prog

Rev D 2-Deburr if necessary

304, 063

13.11-4-4

(16)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

13.11-4-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Split  
Sulay/15

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3564-9

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Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 16.00

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157

11/04/06

16

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

Subar/06

416

-9

150

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat  
m17159 Weld hardcoat as per Dwg D3564

2059B Hardcoat

EL 11-4-06 K12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Item ID: D3564-9

Revision ID:

Item Name: Wearshoe

Start Date: 3/28/2011 Start Qty: 16.00

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Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/  
Run Hours

0.00

0.00

*8 ulw/27*

Tool ID Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*5 ulw/27*

*(+12)*

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME

FINISH TIME

OVEN TEMPERATURE

*3:00*

*1:30*

*2:00*

*12 BR 11-4-27*



W/O:		WORK ORDER CHANGES					
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Monday, March 28, 2011 11:42:48 AM

Page 4

Item ID: D3564-9

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Revision ID:

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Required Date: 3/31/2011 Req'd Qty: 16.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 d 11-04-27

200

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

12 BR 11-4-27

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28  
mf  
11-04-27

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, March 28, 2011 11:42:55 AM

Page 1

Work Order ID: 67590



Parent Item: D3564-9

Parent Item Name: Wearshoe

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 cc  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	4 0000	1.41	23.74737			



304/316 Sheet .063



12-11-4-4

Location	Loc Qty	Loc Code
MAT020	4	
116623	4	

116623  
117075

(16)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	67390
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.222	✓		✓ V302	
2.432	+/-0.010	2.437	✓		✓	
2.50	+/-0.030	2.50	✓		✓	
6.000	+/-0.010	6.000	✓		T 1301	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	301 x 302	✓		✓	
Ø0.188	+0.005/-0.001	0.190	✓		✓	
R0.375	+/-0.010	0.375	✓		R.G.	
0.063	+/-0.010	0.059	✓		✓	

Measured by: H3	Audited by: S	Prototype Approval:	N/A
Date: 11-4-4	Date: 11/04/05	Date:	N/A

Rev	Date	Change	Revised by:	Approved
A	08.01.16	New Issue	KJ/EC/DD	

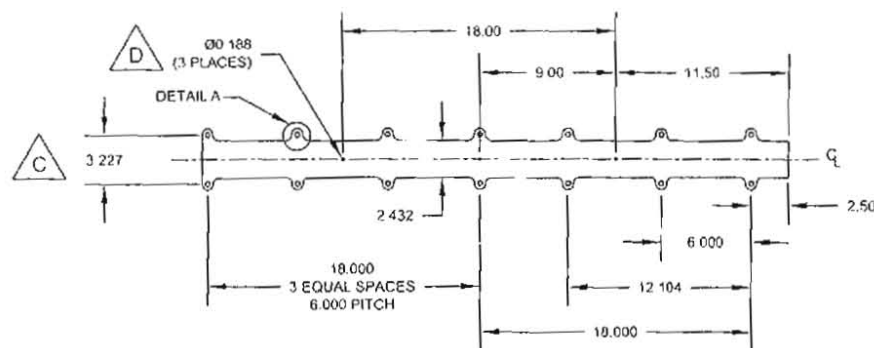
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

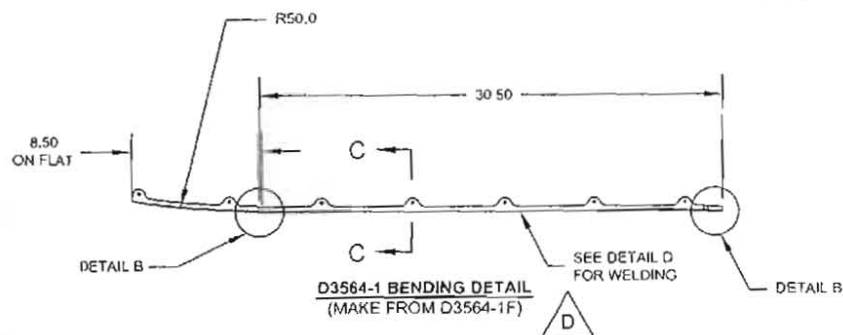
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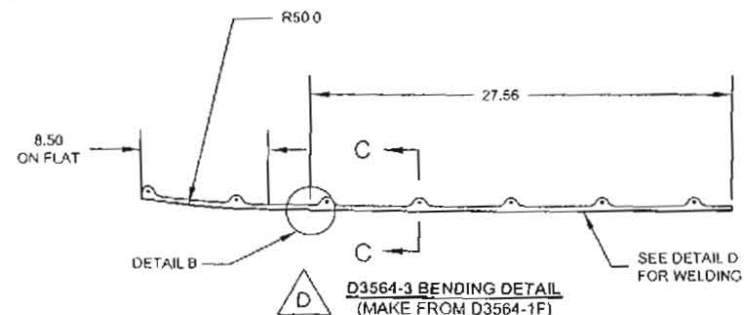
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

104-1/31-51-71-91-11/13/15 WEARPLATE NOTES:  
MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)  
FINISH: POWDER COAT GREY SANDTEX (REF 4.3 5.6) PER DART QSI 005 4.3  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
SHARP EDGES: 0.005 TO 0.015 MAX  
IDENTIFICATION: NONE  
WEIGHT: SEE TABLE IN ZONE A3  
WELD PER DART QSI 004  
SEE PG 3 FOR SECTIONS AND DETAILS  
PARTS ARE SYMMETRIC ABOUT C

WEIGHTS	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B8,B3: D3564-11-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3. D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>*THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE USED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

RELEASED  
07.07.04



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

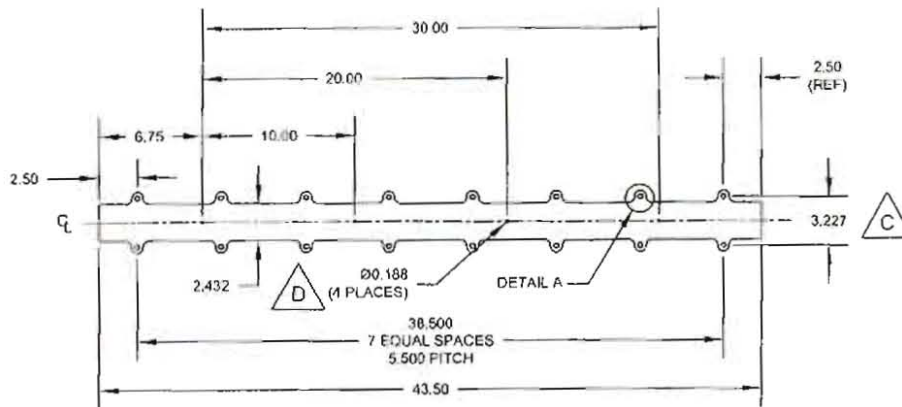
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**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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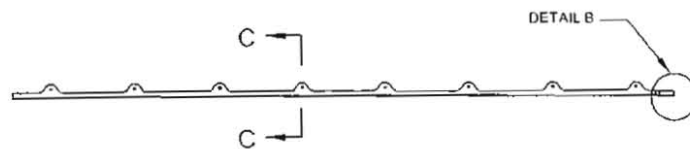
**NOTE:** Date & initial all entries



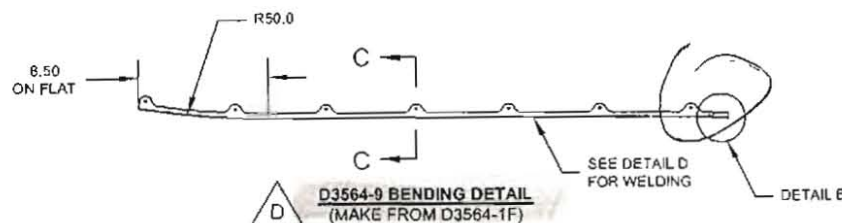
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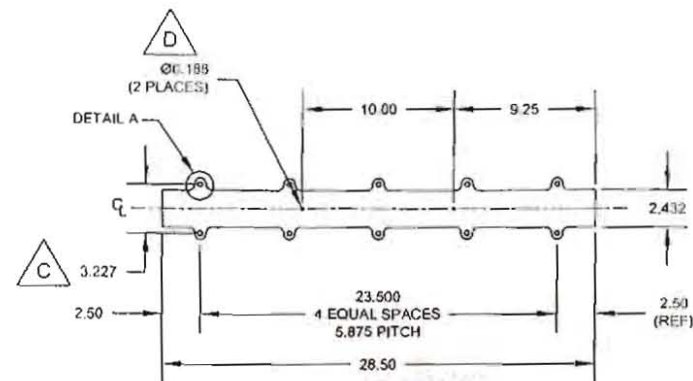
D3564-5F FLAT PATTERN



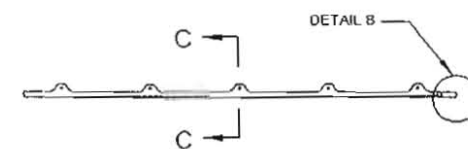
D3564-5 BENDING DETAIL  
(MAKE D3564-5 FROM D3564-5F)



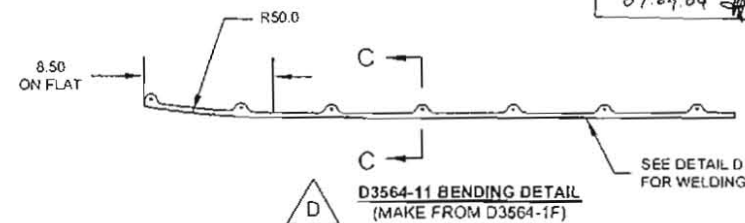
D3564-9 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL  
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without prior written permission from DART AEROSPACE LTD.	

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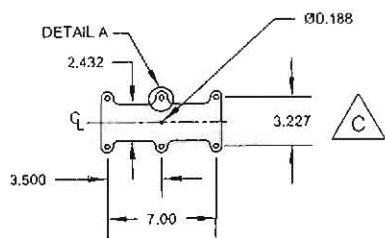
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

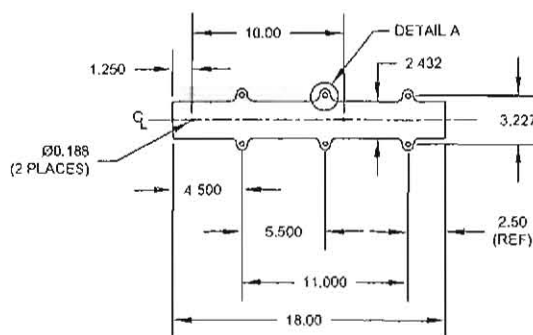
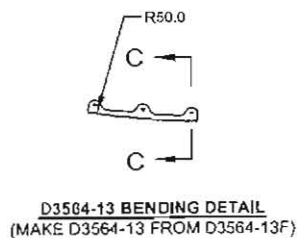
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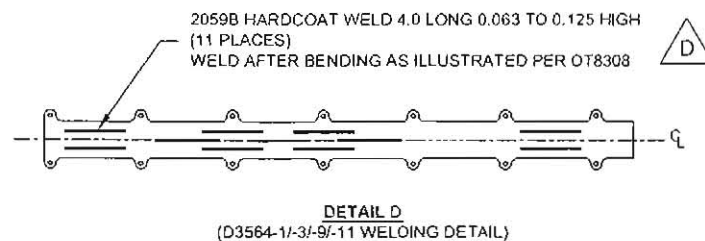
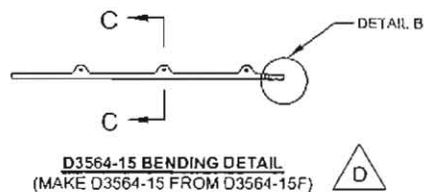
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D3564-13F FLAT PATTERN

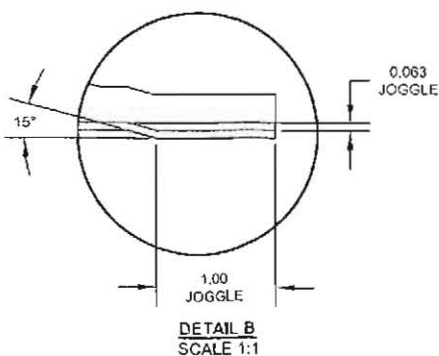
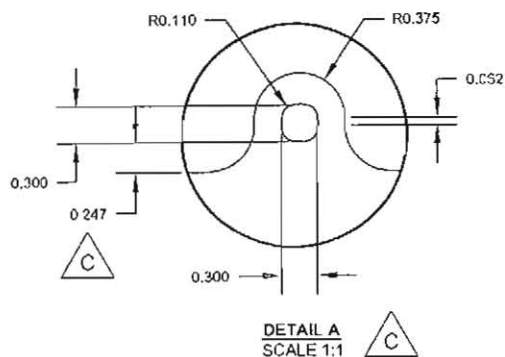
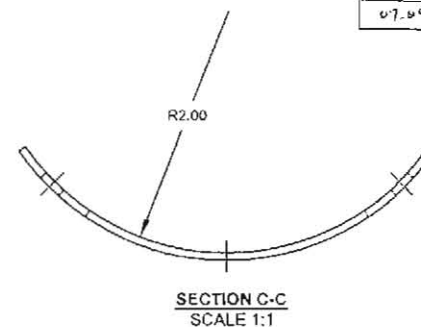


D3564-15F FLAT PATTERN



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07.09.04



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1"
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